

Work Order ID 78264

78264

Page 1

January-04-12 7:54:50 AM

Item ID: D3391-025

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Tube Assembly

Start Date: 04/01/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 10/01/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: M.L.JDate: 12/01/04

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3391

I

100

0.00

100

Mori Seiki

MORI SEIKI CNC LATHE LARGE

Memo

0.00

Mori Seiki CNC Lathe Large

Turn as per Folio FA599 Rev: A & Dwg D3391 Rev: 1

scribe batch # on fwd end at 90 degree

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

111

QC8- Inspect parts - second check

0.00

111

QC

Memo

0.00

Quality Control

INSPECT INSIDE BORE

MML 12/01/05

MML 12/01/05

12/2/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

January-04-12 7:54:50 AM

Item ID: D3391-025 Accept ***N900040100*** Setup Start ***NS1***
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 Item Name: Aft Tube Assembly
 Start Date: 04/01/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 10/01/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00							
120	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1-Machine as per Folio FA 599 Rev: _____ & Dwg D3391 Rev: _____ 2-Deburr								
130		0.00							
130	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									
140		0.00							
140	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control	***INSPECT INSIDE BORE***								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 3

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 Revision ID: Stop *NS2*
 Item Name: Aft Tube Assembly
 Start Date: 04/01/2012 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 10/01/2012 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Skidtubes	0.00							
150									
Skidtubes	Memo	0.00							
Skidtubes	1-Drill (PILOT HOLE) aft cap holes per Dwg D3391 using DT8803								
160	BENDING MACHINE - SKIDTUBES	0.00							
160									
CNC Bend 1	Memo	0.00							
CNC Delta 100 Bender	Form as per Dwg D3391 Using Bend Prog 3391025								
170	QC5- Inspect part completeness to step on W/O	0.00							
170									
QC	Memo	0.00							
Quality Control									

OK 12/02/24

OK 12/02/24

4,15" DP
 12-2-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID 78264

January-04-12 7:54:50 AM

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Page 4

Item ID: D3391-025 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft Tube Assembly
 Start Date: 04/01/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 10/01/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Skidtubes	0.00							
180									
Skidtubes	Memo	0.00							
Skidtubes	1-Open Aft cap pilot hole to .208" as per Dwg D3391								
	2-Drill float bag holes using DT8809 as per Dwg D3391(Holes marked "A" Only.								
	3-Drill wearplate holes as per Dwg D3391 using DT8878(Mid Tube) & DT8217 Wearplate Jig . *****Do Not Open To Finished Size*****								
	4-Drill Wearshoe holes as per DWG D3391 using DT8939 locating from 2 previously drilled aft wearplate holes.								
	5-Open wearplate holes to 0.250" and c'bore as per dwg D3391								
	6-Open up all wearshoe , wearplate to 0.297"and float bag holes to 0.328" as per Dwg D3391.								
	7-Deburr								

31 12/02/27
 DE 12/02/27
 12-2-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Page 6

January-04-12 7:54:50 AM

Item ID: D3391-025 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft Tube Assembly
 Start Date: 04/01/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 10/01/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	Skidtubes	0.00							
220									
Skidtubes	Memo	0.00							
Skidtubes	Instal spacers as per dwg D3391 A/R Magnabond 6398 Batch: 1206666 exp. date: 13-1-30 cure time 12hrs as per QSI0015								
230	QC5- Inspect part completeness to step on W/O	0.00							
230									
QC	Memo	0.00							
Quality Control									
235	Pressure Wash per QSI005 4.3	0.00							
235									
HandFinish	Memo	0.00							
Hand Finishing	AND REALODINE AS PER PAR09-043								

>

DP

12-2-27

S 12/02/28

12/02/28

1 12/02/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 7

January-04-12 7:54:50 AM

Item ID: D3391-025

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Aft Tube Assembly

Stop *NS2*

Start Date: 04/01/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 10/01/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start *NR1*

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
240									
Powdercoat									
Powder Coating									
M 120222									
	Memo	0.00							
	START TIME: 2:45								
	OVEN TEMPERATURE: 320 °F								
	FINISH TIME: 3:15								
250	QC3- Inspect Part Finish	0.00							
250									
QC									
Quality Control	Memo	0.00							
260	HandFinishing	0.00							
260									
HandFinish									
Hand Finishing									
	Memo	0.00							
	1-Install inserts as per Dwg D3391								
	2-Install Aft Cap as per Dwg D3391								
	A/R Sikaflex-241/-291 11/19/08								
	Sikaflex expiry date: 12/09								
	3- INSTALL WEARPLATES AS PER DWG								

120 m-f 12/02/28

X1 12/02/28

12/02/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3391-025 PAR #: _____ Fault Category: Finished / Pause NCR: Yes No DQA: Star Date: 12/3/11
 Resolution: Re work Disposition: Re work QA: N/C Closed: OK Date: 12/3/11

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/02/29	#250	Faew at inspectu Q13 that Powder coat was too thin/missing on top bend aero at about 15.0" in length	S 057042 12/02/29	- strain entile tube - Re Powder coat AS per 057042	M-h 12/02/29	SL 12/02/29 X1	S 12/02/29 057042	S 12/02/29
		R.C. 10A employee Richi	S 12/02/29 057042	Start = 12:30 tend = 3200 F Fin = 1:00	M-h 12/02/29	SL 12/02/29	S 12/02/29 057042	S 12/02/29

NOTE: Date & initial all entries

Work Order ID 78264

78264

Page 8

January-04-12 7:54:50 AM

Item ID: D3391-025 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft Tube Assembly
 Start Date: 04/01/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 10/01/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270 *270* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		812/02/29					
280 *280* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00							12/12/29
290 *290* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							MLJ 12/02/29 MK 12-02-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

January-04-12 7:54:53 AM

Page 1

Work Order ID: 78264

78264

Parent Item: D3391-025

D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 04/01/2012

Required Date: 10/01/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev B 06-02-07 ECN773 dwg rev. D EC
 IPP Rev:C 06-03-28 Update Manuf. Instructions JLM
 IPP rev D 07.03.20 revF dwg EC
 IPP rev E 07.11.07 rev G dwg ecn 1053p EC verified by: DD
 IPP Rev:F 07-11-13 ECN 1056 DD verified by: EC
 IPP Rev:G 08-09-10 revH as per dwg DD verified by:EC IPP Rev:H
 11.11.14 AS PER REV.I DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4095-047		Manufactured	No			260	Each	11.0000	1	1			
D4095-047													
Wearpad Assembly													

** 378325 (X1) JLM 12/02/29

Location	Loc Qty	Loc Code
FP001	11	
77435	11	

D4095-049		Manufactured	No			260	Each	18.0000	1	1			
D4095-049													
Wearpad Assembly													

** JLM 12/02/29

Location	Loc Qty	Loc Code
FP002	18	
76538	11	
77436	7	

D6014-090		Manufactured	No			100	Each	2.0000	1	1			
D6014-090													
ALUMINUM EXTRUSION													

**

Location	Loc Qty	Loc Code
LG	2	
66179	2	

1 amm.k 12/01/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

January-04-12 7:54:53 AM

Page 2

Work Order ID: 78264

78264

Parent Item: D3391-025

D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 04/01/2012

Required Date: 10/01/2012

Start Qty: 1.00

Required Qty: 1.00

D3670-4-200

Manufactured No

230

Each

31.0000

4

4

D3670-4-200

SPACER

**

BE 12/02/27

Location

Loc Qty

Loc Code

LG001

31

72851

31

77500 270

Each

143.0000

1

1

**

XL 12/02/29

D2646

Manufactured No

D2646

Aft Cap

Location

Loc Qty

Loc Code

FP002

143

62678

5

68280

5

70945

1

71038

4

71070

2

73294

1

73825

125

X1

D3672-1

Manufactured No

270

Each

1,004.000

2

2

D3672-1

Phenolic Washer

**

XL 12/02/29

Location

Loc Qty

Loc Code

FP001

362

66821

362

ST074

642

72229

142

76277

500

X7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Page 3

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Parent Item: D3391-025

Parent Item Name: Aft Tube Assembly

78264

D3391-025

Start Date: 04/01/2012

Required Date: 10/01/2012

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-130

Purchased

No

260

Each

2,088.000

14

14

AI S4-1032-130

Insert

1120671 (x14) J4 12/02/29

Location

Loc Qty

Loc Code

ST280

1968

119084

1968

ST281

120

119632

120

ALS4-1032-225

Purchased

No

270

Each

1,094.000

8

8

AI S4-1032-225

Insert

11120451 (x8) J4 12/02/29

Location

Loc Qty

Loc Code

ST281

1094

108696

199

110768

62

118386

765

118966

68

AN3C4A

Purchased

No

270

Each

1,388.000

6

6

AN3C4A

BOLT

1120521 (x6) J4 12/01/29

Location

Loc Qty

Loc Code

ST350

1388

117313

2

117688

5

117872

10

118112

16

118451

2

118838

118

119328

235

119749

1000

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 4

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Parent Item: D3391-025

D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 04/01/2012

Required Date: 10/01/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C5A

Purchased

No

270

Each

864.0000

4

4

AN3C5A

**

all alorza

Bolt

Location

Loc Qty

Loc Code

FP001

7

115835

7

ST350

857

116419

28

117343

17

117764

49

117872

2

119127

500

119749

261

x2

AN960C10L

NAS1149C0332
R

Purchased

No

270

Each

0.0000

10

10

***AN960C10I ***

**

x1120648 (x10) all alorza

washer

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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DART AEROSPACE LTD		Work Order: 78264
Description: Float Skidtube (412)		Part Number: D3391-3
Inspection Dwg: D3391	Rev: H	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Lathe Section						
14.000	+/-0.010	14.000	✓		tape	mm-L-02
3.500	+/-0.010	3.503	✓		vern	calc-06
88.93	+/-0.030	88.930	✓		tape	mm-L-02
Ø3.200	+/-0.010	3.201	✓		vern	calc-06
88.93	+/-0.030	88.930	✓		tape	mm-L-02
Ø3.750	+/-0.010	3.750	✓		vern	calc-06
30° x 160° chamfer	+/-0.010	30° x 160°	✓		11	

Measured by: mm-L	Date: 12/01/05
Audited by: [Signature]	Date: 12/2/24

HAAS Section						
1.526	+0.000/-0.030	1.510	✓		Re-14	
7.500	+/-0.010	7.5	✓		29-07	
27.750	+/-0.010	27.75	✓			
31.750	+/-0.010	31.75	✓			
35.250	+/-0.010	35.25	✓			
3.300	+/-0.010	3.303	✓			
0.200	+/-0.010	.198	✓			
3.520	+/-0.010	3.518	✓			
0.687	+0.010/-0.000	.695	✓			
R0.062	+/-0.010	R0.062	✓			
Ø0.484	+0.005/-0.001	.488	✓			

Measured by: [Signature]	Date: 12.2.22
Audited by: [Signature]	Date: 12/2/24

Rev	Date	Change	Revised by	Approved
A	06.04.24	New Issue P/O D3391-015/-025	KJ/JLM	
B	06.06.19	Dwg revision update	KJ/JLM	
C	07.04.20	Ø0.208 dimension removed	KJ/JLM	
D	07.09.06	0.400 dimension removed	KJ/JLM	
E	07.11.23	Dwg Rev. updated	KJ/EC/DD	
F	09.04.27	Dimensions updated per Rev H and NCR09-028	KJ/JLM	
G	09.11.16	Dimension 0.200 removed	KJ	
H	11.06.21	Dimension 44.995 removed	KJ	

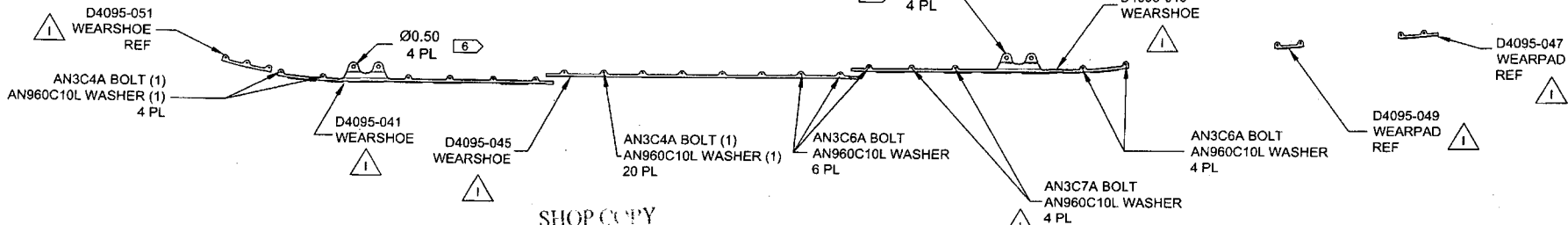
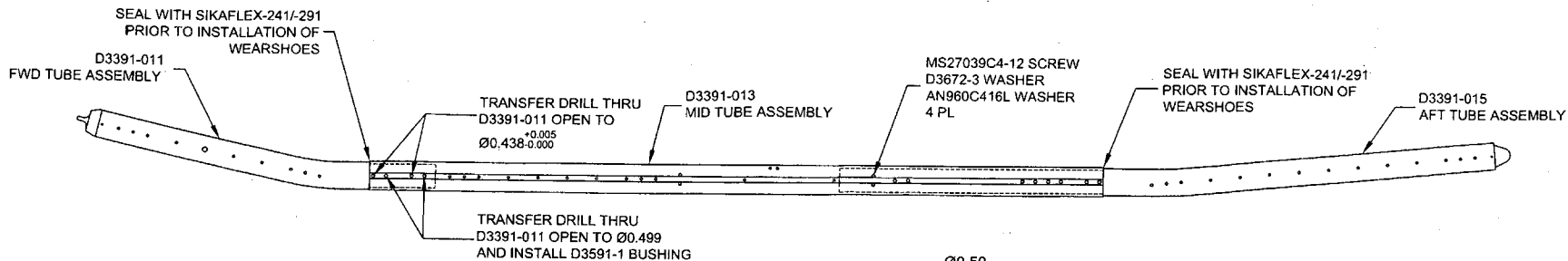
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NOTE: Date & initial all entries



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WORK ORDER
NO. 78264-4.0.5
12/01/04

D3391-041 ASSEMBLY



D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
-041		
X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
1	D3391-011	FWD TUBE ASSEMBLY
1	D3391-013	MID TUBE ASSEMBLY
1	D3391-015	AFT TUBE ASSEMBLY
2	D3591-1	BUSHING
4	D3672-3	WASHER
1	D4095-041	WEARSHOE
1	D4095-043	WEARSHOE
1	D4095-045	WEARSHOE
1	D4095-047	WEARPAD
1	D4095-049	WEARPAD
1	D4095-051	WEARSHOE
24	AN3C4A	BOLT
10	AN3C6A	BOLT
4	AN3C7A	BOLT
38	AN960C10L	WASHER
4	MS27039C4-12	SCREW
4	AN960C416L	WASHER

GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.
- 6) FIT D4095-041 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-041
- 7) FIT D4095-043 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-043

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I	REMOVE GASKETS AND REPLACE ALL WEARSHOES; PARTS LIST UPDATE, ZN A8-1, ZN A8-2, ZN A8-4, ZN B6-8; LPS-3 COATING REMOVED FROM NOTE 2, ZN A3-1, ZN A3-2, REMOVED INSERT AELS-1032-130, ZN B6-4, B2-4, C7-8, C3-8; REMOVED HOLES, ZN D6-4 ZN D2-4, ZN D7-8, ZN D3-8	XDF	11.10.13
H	DRAWING UPDATED TO CURRENT STANDARDS. SHT 1 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. SHT 2 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. (FOR FURTHER INFO SEE DSI 9364 & NCR 08-074)	AJS	08.08.20
G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC KENT, WA	
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MFG. APPR.		D3391	SHEET 1 OF 8
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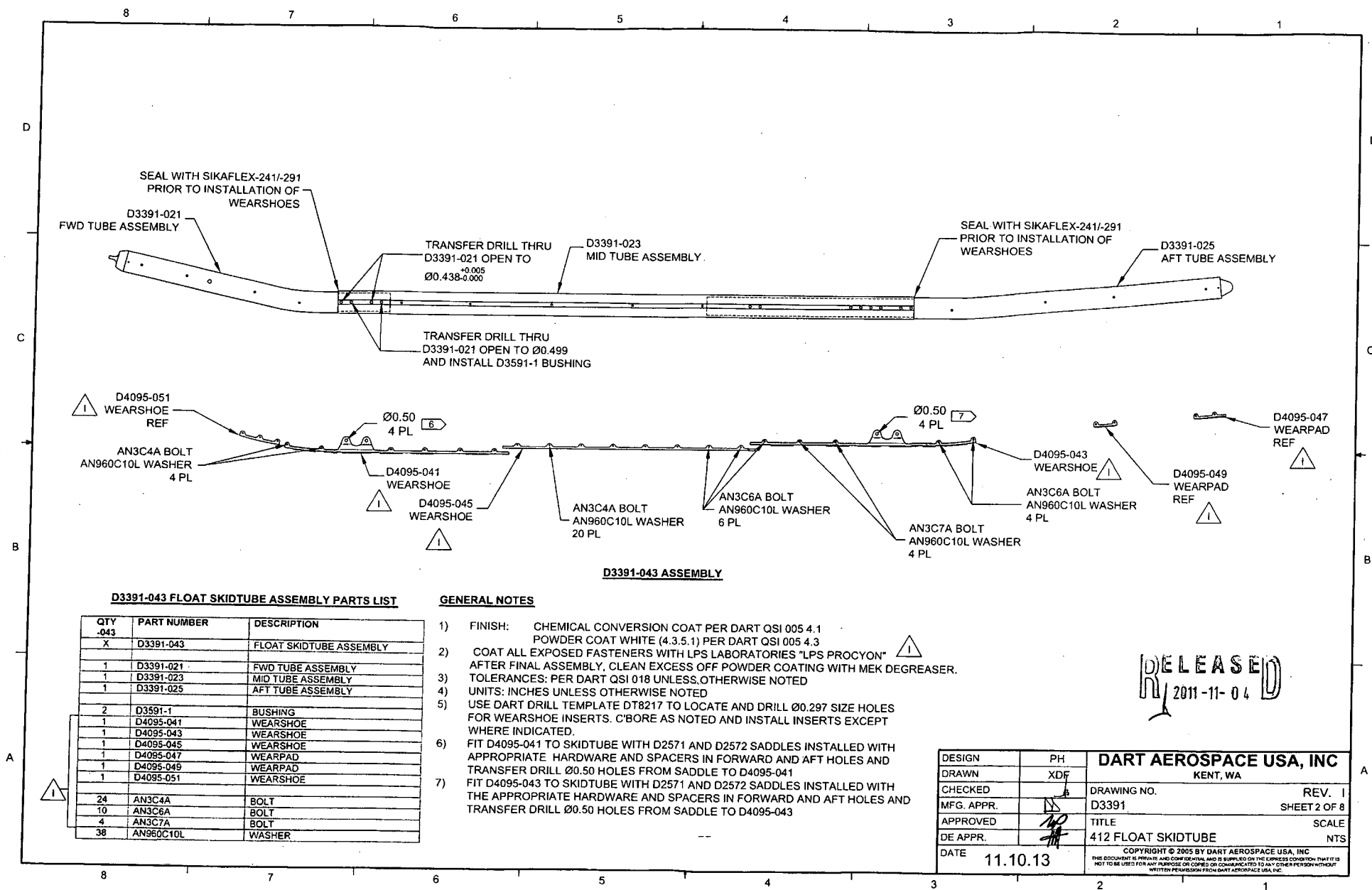
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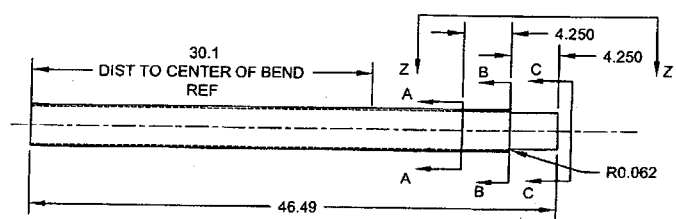
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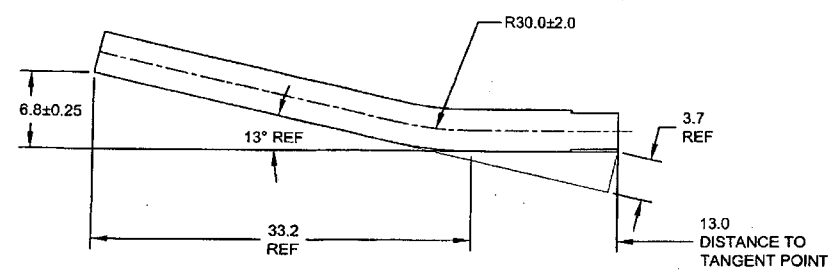
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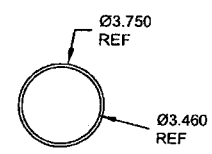
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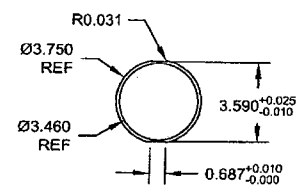
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



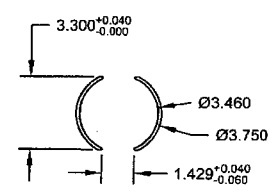
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



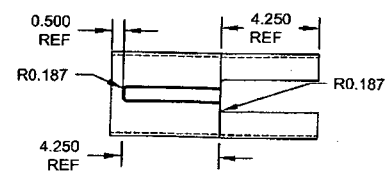
SECTION A-A
SCALE 2X



SECTION B-B
SCALE 2X



SECTION C-C
SCALE 2X



VIEW Z-Z
SCALE 2X

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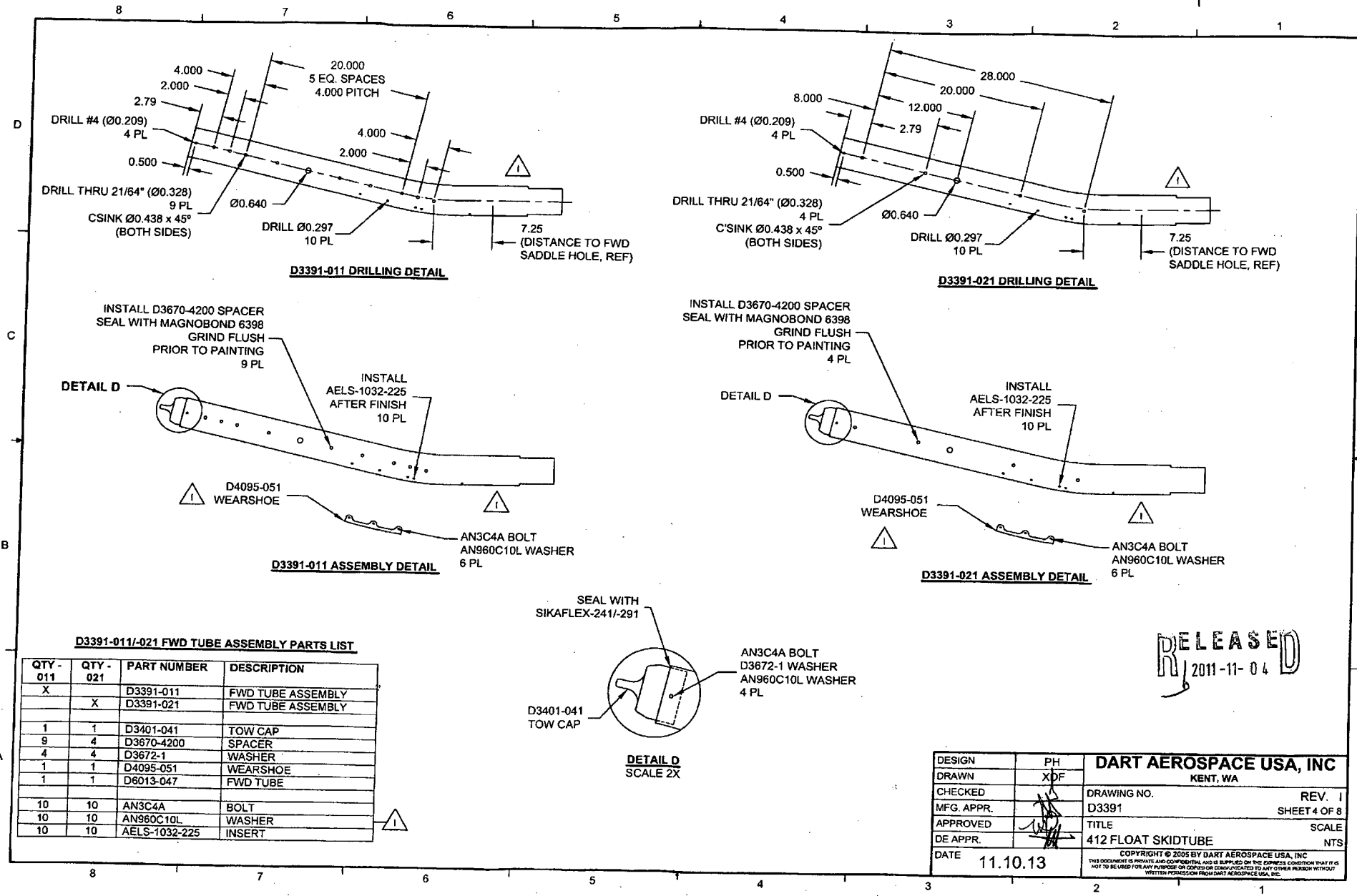
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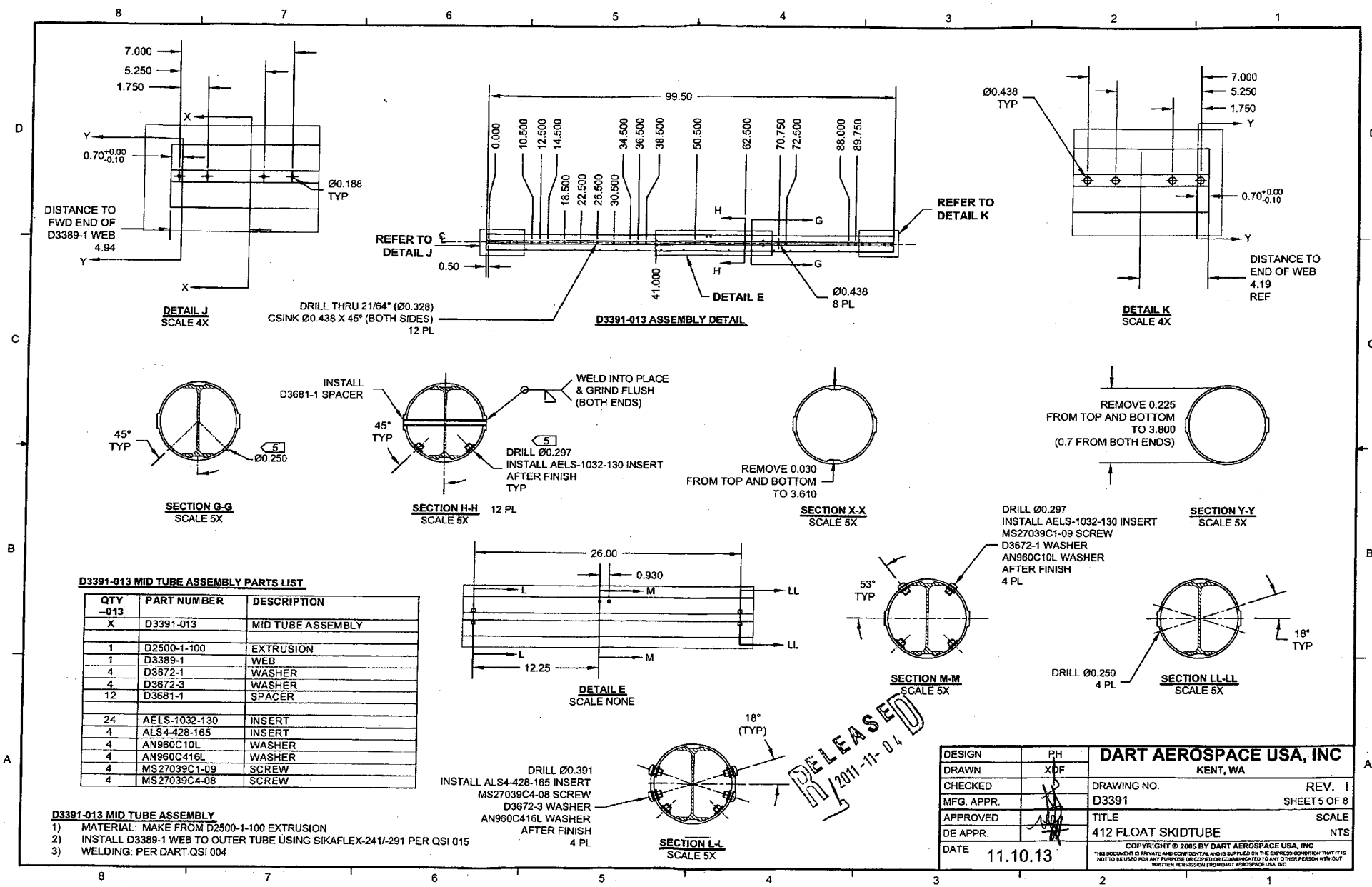
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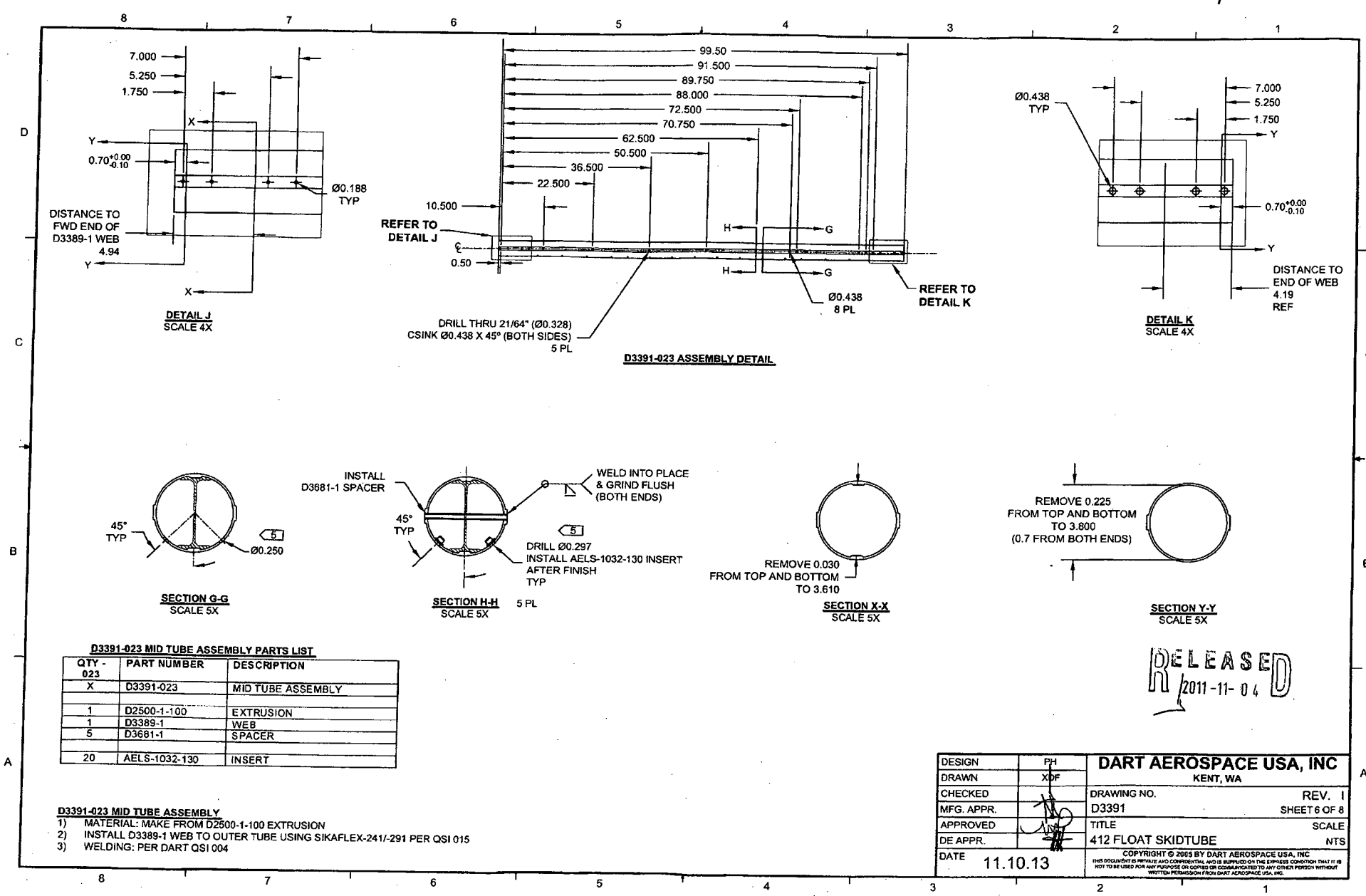
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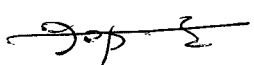
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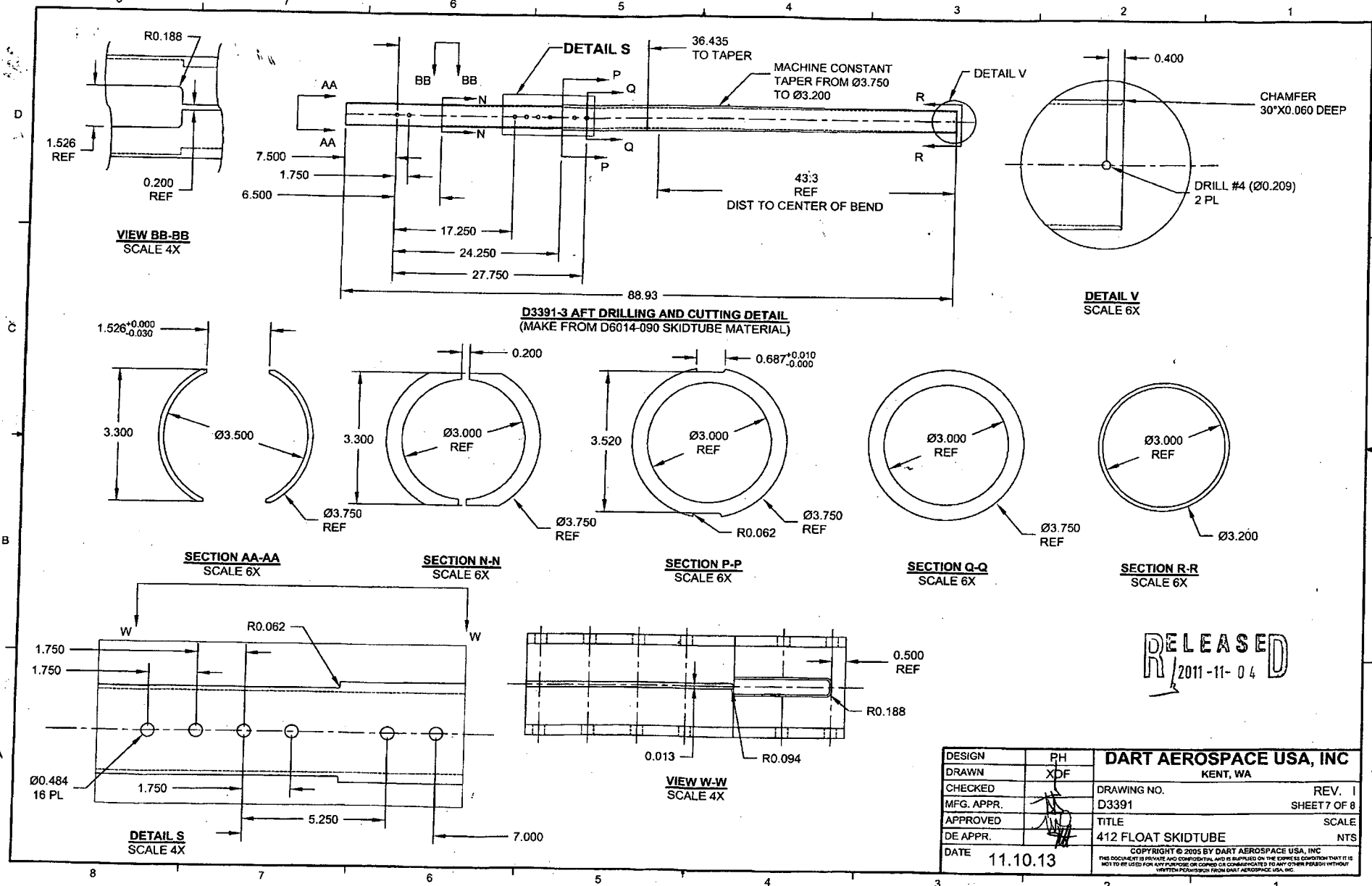
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8 7 6 5 4 3 2 1

D

R30.0±2.0
36.000
9 EQ. SPACES
4.000 PITCH
4.000
2.000
2.69
U
U
9.1
DISTANCE BETWEEN HOLE AND TANGENT POINT
7.00 REF
DRILL Ø0.297
22 PL
53.7
DRILL THRU 21/64" (Ø0.328)
14 PL
CSINK Ø0.438 X 45°
(BOTH SIDES)
4.2±0.25

D3391-015 BENDING AND DRILLING DETAIL
(SEE CBORE DETAIL BELOW)

INSTALL D3670-4200 SPACER
SEAL WITH MAGNOBOND 6398
GRIND FLUSH
PRIOR TO PAINTING
14 PL

C

3.750
CC
OC
CB3
CB2
CB4
(NO CBORE)
CB1
DETAIL T

D3391-015 ASSEMBLY AND CBORE DETAIL
(SEE TABLE)

D4095-049 WEARPAD
AN3C5A BOLT
AN960C10L WASHER
4 PL
D4095-047 WEARPAD
AN3C4A BOLT
AN960C10L WASHER
4 PL

D3391-015/-025 AFT TUBE ASSEMBLY PARTS LIST

QTY - 015	QTY - 025	PART NUMBER	DESCRIPTION
X	X	D3391-015	AFT TUBE ASSEMBLY
		D3391-025	AFT TUBE ASSEMBLY
1	1	D2646	AFT CAP
14	4	D3670-4200	SPACER
2	2	D3672-1	WASHER
1	1	D4095-049	WEARPAD
1	1	D4095-047	WEARPAD
1	1	D6014-090	AFT TUBE
14	14	AELS-1032-130	INSERT
8	8	AELS-1032-225	INSERT
4	4	ALS4-428-165	INSERT
6	6	AN3C4A	BOLT
4	4	AN3C5A	BOLT
10	10	AN960C10L	WASHER

CBORE HOLES MARKED CB1-CB4 AS FOLLOWS AND INSTALL AELS-1032-XXX AFTER FINISH AS NOTED

HOLES MARKED	QTY D3391-015	QTY D3391-025	CBORE	P/N
CB1	8	8	Ø0.430 X 0.170	AELS-1032-225
CB2	4	4	Ø0.430 X 0.170	AELS-1032-130
CB3	6	6	Ø0.430 X 0.040	AELS-1032-130
CB4	4	4	NONE	AELS-1032-130

SECTION U-U
SCALE 3X

18° TYP

SECTION CC-CC
SCALE 3X

DRILL Ø0.391
CBORE Ø0.516 X 0.040 DEEP
INSTALL ALS4-428-165 INSERT
4 PL

D2646 AFT CAP
SEAL WITH SIKAFLEX-241/291

AN3C4A BOLT
D3672-1 WASHER
AN960C10L WASHER
2 PL
DETAIL T
SCALE 4X

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APPROVED
DE APPR.
DATE 11.10.13

DART AEROSPACE USA, INC
KENT, WA

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SHEET 8 OF 8

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